

Date: Monday, 05/03/2007 12:34:27 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG	
Job Number	: 30993		Part Number	: D22303	
Estimate Number	: 10256		Drawing Number	: D2230 REV F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 05/03/2007	S.O. No. : N/A	Drawing Revision	: F	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 01/03/2007	Type : MACHINED PARTS	Due Date	: 03/12/2007	
Previous Run	: 30545		Qty:	1,000	Um: Each
Written By				CO	
Checked & Approved By					
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion   Comment: Qty.: 0.0717 f(s)/Unit Total : 71.7150 f(s) Lug Extrusion D2423 Batch: B30062
2.0	BAND SAW	BAND SAW   Comment: Band Saw Cut D2423 extrusion to 0.82" Batch:
3.0	PG	PURCHASING   Comment: PURCHASING Issue P/O BLKT0001 Possible Supplier : Metec Machine per Drwg D2230 Rev. F 30-June 12, 2007 124-June 15, 2007 60-June 18, 2007 C2070308
4.0	PACKAGING 1	PACKAGING RESOURCE #1   Comment: PACKAGING RESOURCE #1 Receive & Inspect for transit damage 

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Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*R*  
*7/6/07/09*



6.0 SMALL FAB 1

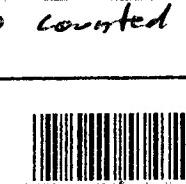
SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

*CAD 05/06/24 60 counted*

Tumble and deburr rough edges after tumbling



7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1

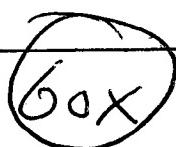


Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*M-1*

*07/07/05*



8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT WORK TO CURRENT STEP

*207-07-05*



9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*M 101 575*

*BR/FZ.*

*07-07-05*



10.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ INSPECT POWDER COAT

*207-07-05*



11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EPA 07/07/05*



12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



*107-07-05*

Job Completion



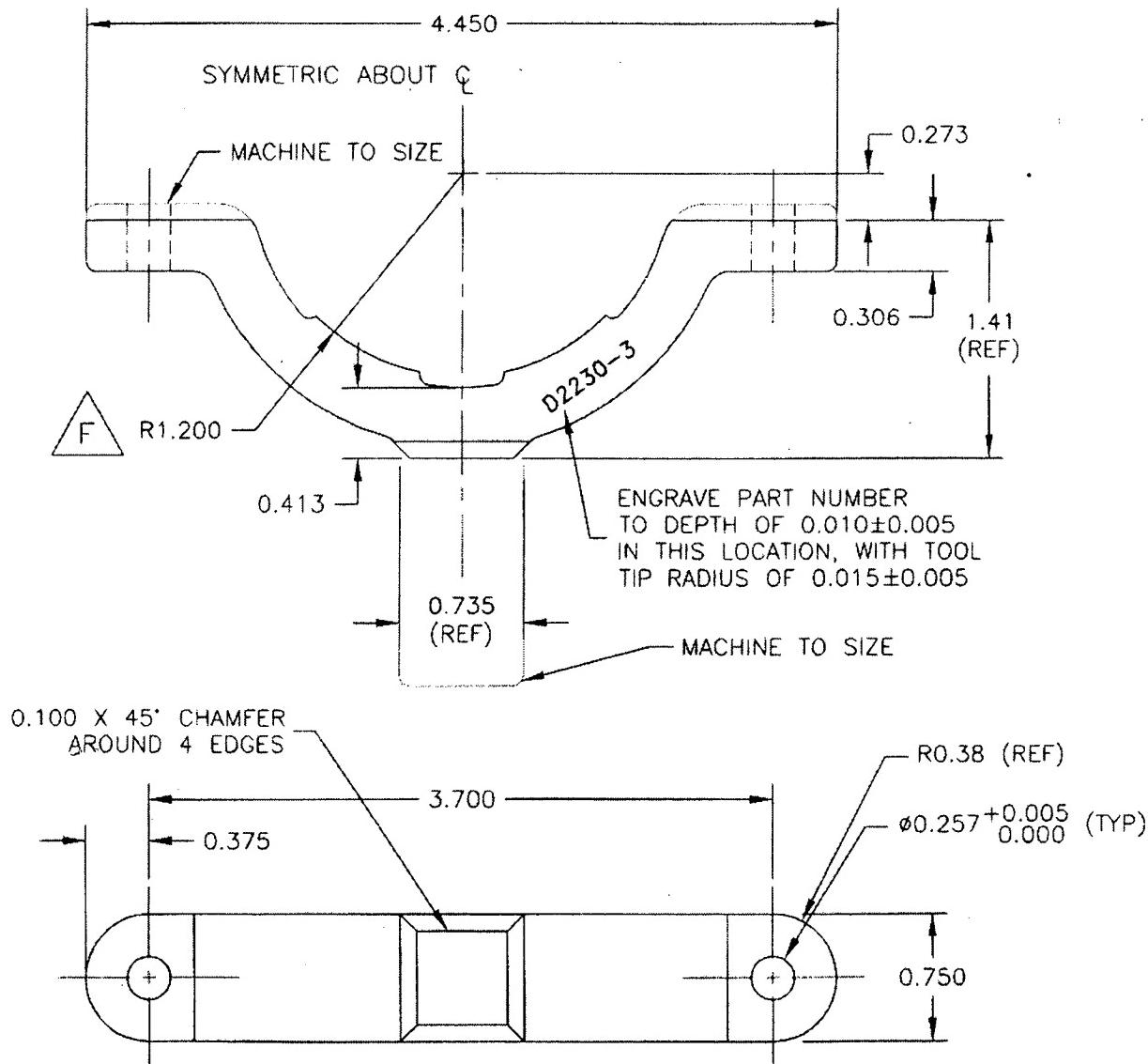
*207/07/09*



COPY ISSUED  
10

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG SCALE 1:1

RELEASED  
19.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED